

Work Order ID 60038

June 23, 2010 10:11:52 AM

Page 1

Item ID: D3191-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Backer Plate

Start Date: 6/23/10 Start Qty: 2.00

Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 10/6/23 Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3191

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3191

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B 10-6-23

6061.063

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8061063

(72)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3191-5

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>MA</i>	<i>10</i>	<i>06</i>	<i>24</i> (2)
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <i>11:45</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>12:15</i>	0.00 0.00				<i>2</i>	<i>10</i>	<i>06</i>	<i>10-6-28</i>
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>MA</i>	<i>10</i>	<i>06</i>	<i>28</i> (2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60038

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Page 3

Item ID: D3191-5

Accept



Setup Start

Revision ID:

Stop

Item Name: Backer Plate

Start Date: 6/23/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 040

0.00



Packaging

Memo

0.00

Packaging

Signature *2*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29
MF
10-6-29

Picklist Print

June 23, 2010 10:11:51 AM

Page 1

Work Order ID: 60038



Parent Item: D3191-5



Parent Item Name: Backer Plate

Start Date: 6/23/10

Required Date: 6/25/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.23 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	122.0000	0.10999	0.231558			
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT21

122

113608

122

113608

1810-6-23

②

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

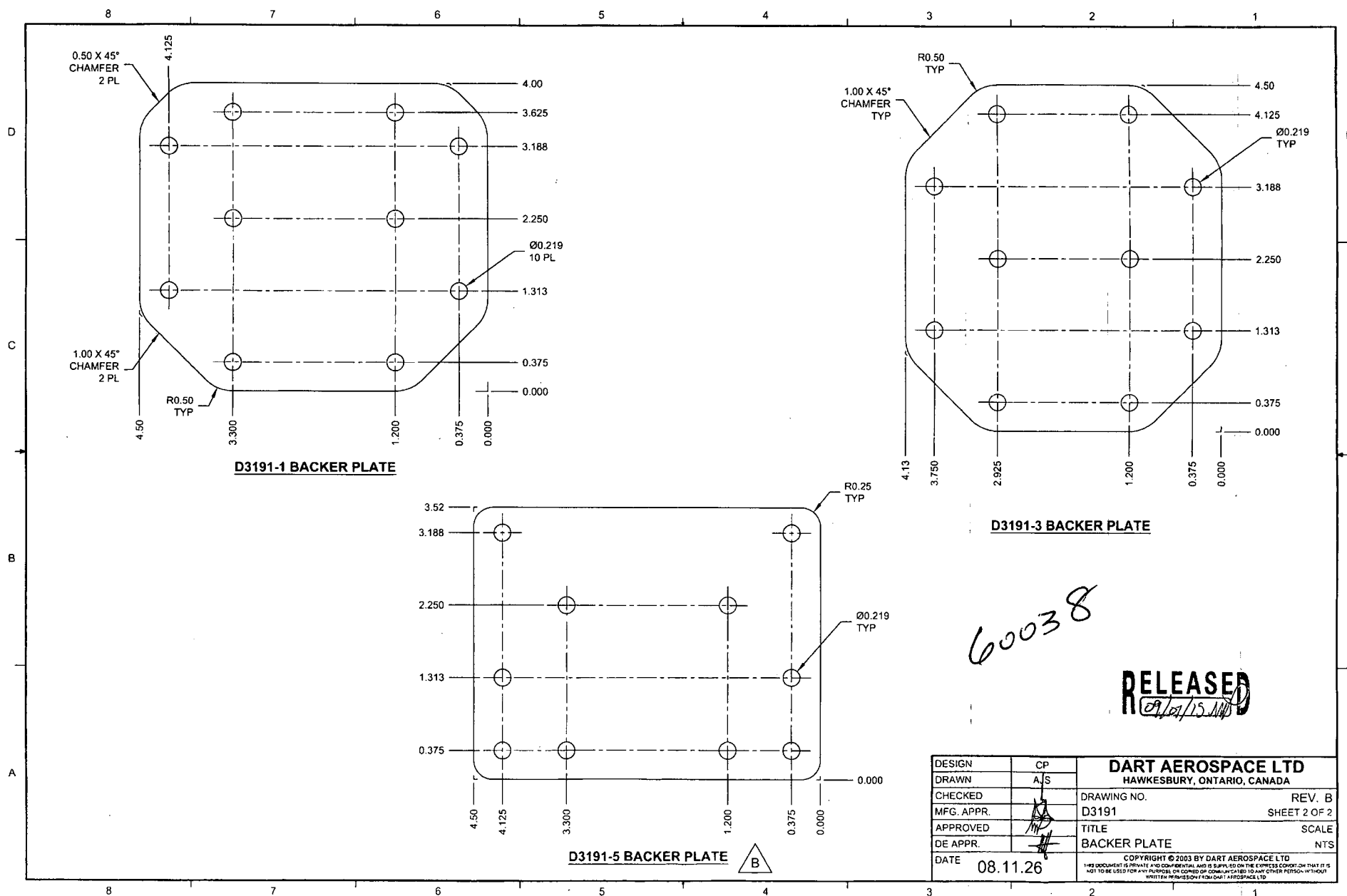
8E007:010
 22/9/0120

RELEASE
 09/2/15

NOTES:





- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3191-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -1: 0.10 lbs
 -3: 0.10 lbs
 -5: 0.09 lbs

B	TRANSFERRED TO "B" SIZE DRAWING AND UPDATED TO CURRENT STANDARDS. ADDED -5. REASON: SEE NCR 08-110.		AJS	08.11.26
A	NEW ISSUE		CP	03.05.27
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3191	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BACKER PLATE	NTS	
DATE	08.11.26		<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



60038

RELEASED
09/21/15

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3191	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACKER PLATE	NTS
DATE	08.11.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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